



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2662-2
Job Sheet 212585



Part No: D2662-2

Job Qty: 4 pcs

Part Name: Saddle, LH Fwd, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/27/20

Job Tracking No:

Due Date: 8/31/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV E IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP REV:D REDESIGN
PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	4 pcs	8/29/20		0.00	0.00	HAAS - 1	DAS 52	22/08/30
							HAAS - 2	52	
							HAAS - 3	9-89	
							HAAS - 4		
100	HAAS 4 Axis - B4B	4 pcs	8/29/20		1.00	4.96	HAAS - 1 - B4B		22/08/31
							HAAS - 2 - B4B		
							HAAS - 3 - B4B	DAS 52	
							HAAS - 4 - B4B	9-89	
110	Conventional Mill - 1 - B4B	4 pcs	8/29/20		0.00	1.02	Conventional Mill - 1 - B4B	DAS 52	22/08/31
							Conventional Mill - 2 - B4B	9-89	
120	QC 2	4 pcs	8/29/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		



Container No: S297234



Part: D2662-2

Job No: 212585

Serial No/Batch: S297234

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/29/20

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				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	DAS
				QC 2 - 52	52 20/08/31
				QC 2 - 57	9-89
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130 QC 8	4	8/29/20	0.00 0.00	QC 8 - 12	
	pcs			QC 8 - 14	20/08/31
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
140 Handfinish - 1-1 Chemical-B4B	4	8/29/20	0.00 0.12	Handfinish - 1 - 1 - B4B	
	pcs			Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	

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					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White Gl(A)- B4B	4 pcs	8/31/20	0.00 0.12	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
					Powdercoat - 5 - B4B	
					Powdercoat - 6 - B4B	
					Powdercoat - 7 - B4B	
					Powdercoat - 8 - B4B	
					Powdercoat - 9 - B4B	
					Powdercoat - 10 - B4B	
160	QC 3	4 pcs	8/31/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
					QC 3 - 47	
170	Packaging 3-1 - Stock - B4B	4 ✓ pcs	8/31/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	

2020/09/03

20-09-3

DAS
40
9-89

SEP 03 2020

DAS
80
9-89

SEP 03 2020

5401

				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	4 pcs	8/31/20	0.00 0.00	QC 21 - SA - 21-	
				QC 21 - SA - 70	
				Broussard	SEP 03 2020 DAS 70
				QC 21 - SA - 9	9-89
				QC 21 - SA - 77	

Part Op 100 - (HAAS CNC Vertical Machine), Program part number and batch number. Inspect part number and batch number are
 Descriptions: programmed MACHINE AS PER FOLIO FB069 & DWG DWG REV: E FOLIO REV: AA
 110 - (Manufacture as per dwg), Machine Keyway and inspect per attached dimension sheet
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

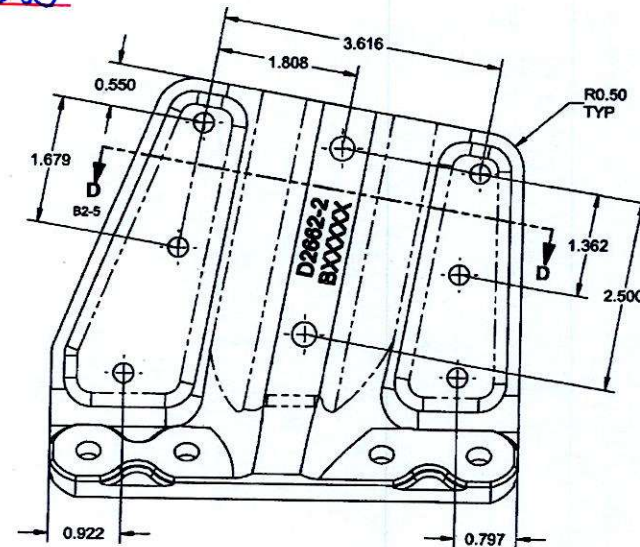
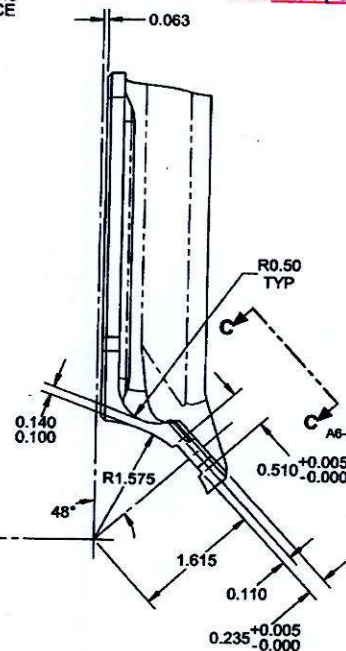
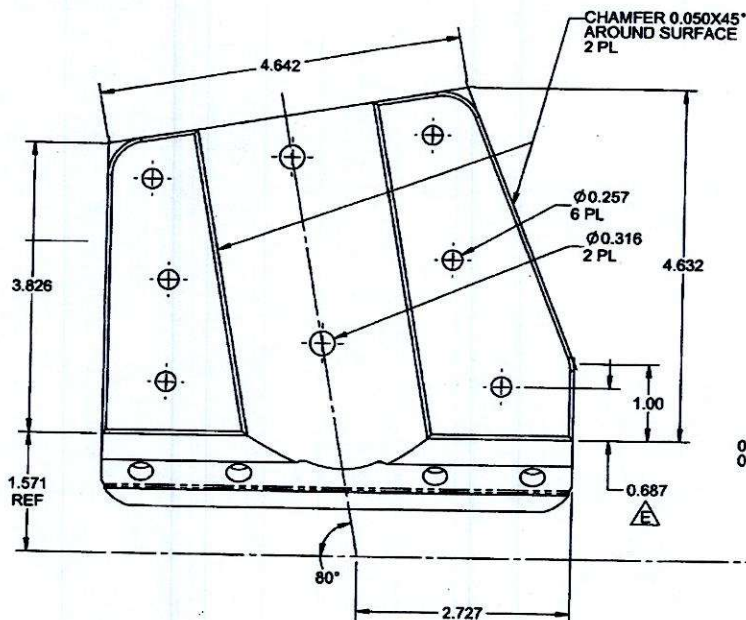
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 pcs (1 ea)	90-Machining - Issue SN	5291208

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-001	4	5	0

Part Specifications
Specifications could not be found.

Plex 8/27/20 10:04 AM Dart.Renwick.Jennifer

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 212585

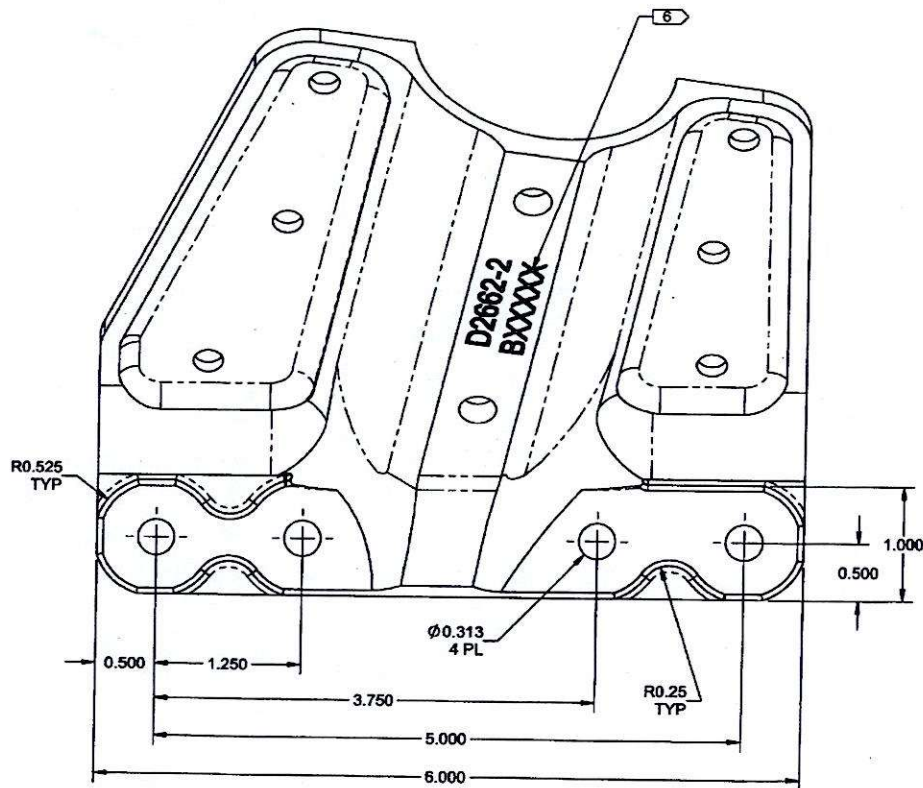


RELEASED
2011-11-16

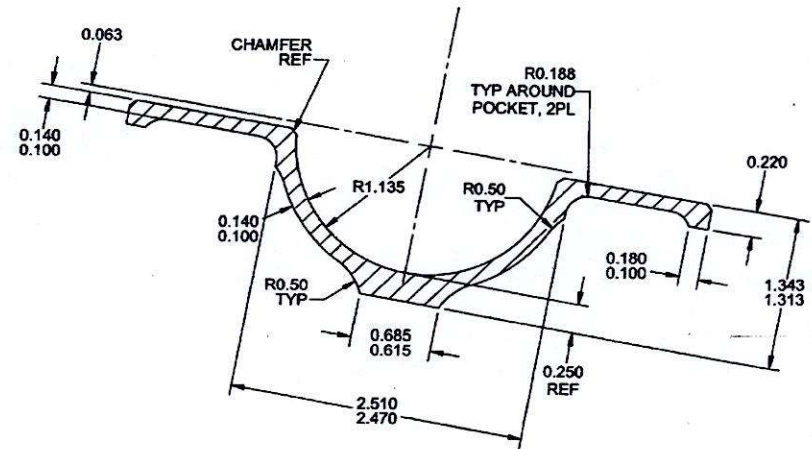
D2662-2 SADDLE, INSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209 MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING) USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC.	



VIEW D-D 84-4
SCALE 1.5X
VIEW ROTATED



VIEW C-C C3-4
SCALE 1.5X

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC.	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 212585
Description: 206 Saddle, Inboard, Left side		Part Number: D2662-2
Inspection Dwg: D2662	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.615	3.615	3.615	3.615	
B	0.256	0.263		0.258	0.258	0.258	0.258	
C	0.315	0.322		0.312	0.312	0.312	0.312	
D	2.495	2.505		2.500	2.500	2.500	2.500	
E	1.674	1.684		1.679	1.679	1.679	1.679	
F	0.100	0.140		0.126	0.122	0.122	0.122	
G	0.210	0.230		0.222	0.210	0.219	0.219	
H	0.615	0.685		0.685	0.685	0.685	0.685	
I	2.470	2.510		2.490	2.490	2.490	2.490	
J	1.313	1.343		1.327	1.323	1.323	1.323	
K	0.178	0.198		0.188	0.188	0.188	0.188	
L	0.470	0.530		0.500	0.500	0.500	0.500	
M	1.125	1.145		1.135	1.135	1.135	1.135	
N	0.100	0.180		0.140	0.140	0.140	0.140	
O	0.100	0.140		0.135	0.133	0.136	0.136	
P	0.240	0.260		0.252	0.247	0.246	0.246	
Q	0.677	0.697		0.688	0.688	0.688	0.688	
R	0.540	0.560		0.550	0.549	0.551	0.551	
S	0.912	0.932		0.922	0.922	0.922	0.922	
T	0.787	0.807		0.797	0.798	0.798	0.798	
U	5.990	6.010		6.002	6.003	6.002	6.002	
V	4.995	5.005		5.000	5.000	5.000	5.000	
W	0.490	0.510		0.500	0.497	0.501	0.501	
X	0.312	0.319		0.313	0.313	0.313	0.313	
Y	0.990	1.010		1.000	1.000	1.000	1.000	
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	
AB	0.490	0.510		0.501	0.500	0.499	0.501	
AC	3.745	3.755		3.750	3.750	3.750	3.750	
AD	0.100	0.140		0.137	0.132	0.128	0.134	
AE	0.235	0.240		0.238	0.238	0.238	0.238	
AF	0.510	0.515		0.512	0.512	0.512	0.512	
AG	0.100	0.120		0.120	0.125	0.123	0.119	
AH	1.565	1.585		1.575	1.575	1.575	1.575	

DAS

Accept/Reject

Measured by: 52	Date: 20/08/31
Audited by: [Signature]	Date: 20/08/31
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	[Signature]